

Work Order ID 86700

86700

Page 1

July-06-12 11:36:34 AM

Item ID: D3084-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Strut

Start Date: 7/06/12

Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/03/12

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date: 12-07-17

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3084

C

100

0.00

100

BAND SAW

Small Fab

Memo

0.00

Small Fab

1- Punch per Dwg. D3084 and spec control dwg D2638
2-Debur

110

QC5- Inspect part completeness to step on W/C

0.00

110

QC

Memo

0.00

Quality Control

120

Weld per dwg A/R Aluminum rod Batch: M120854 0.00

120

Large Fab

Large Fab

Memo

0.00

Large Fab

1- Weld ends per dwg.
2- Grind flush

SB 12-07-17

3

DAS 16 12/07/17

43

3

12-7-18
Ae 12-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC10- Inspect visual per QSI004- ground welds

0.00

130

QC

Memo

0.00

Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

145

Alodine

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:00
3200 F
12:30

(+3)
3X
3X
M/L
12/07/23
M/L
12/07/23

M121279

W/O: 86700		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
120723	145	permanent change	<i>[Signature]</i>			<i>[Signature]</i> 120723	

Part No: D3084-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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86700

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N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

2

2

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

160

QC

Memo

0.00

Quality Control

Identify as per dwg & Stock Location: 0.00

170

Packaging

Packaging

Memo

0.00

QC21- Final Inspection - Work Order Release	0.00
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180

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Picklist Print

July-06-12 11:36:34 AM

Page 1

Work Order ID: 86700

Parent Item: D3084-3

Parent Item Name: Strut

Start Date: 7/06/12

Required Date: 8/03/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A nerw issue DD 10.04.26 verified by:EC
REV.C DD verified by:EC

IPP Rev:B 10.10.13 AS PER DWG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.750W.058		Purchased	No			100	f	140.9500	2.4833	5.228			
6061-T6 RD Tube .750 x.058W													

Location

Loc Qty

Loc Code

MAT015

140.95

10099

24

112652

116.95

8.5

Sp 12/02/12

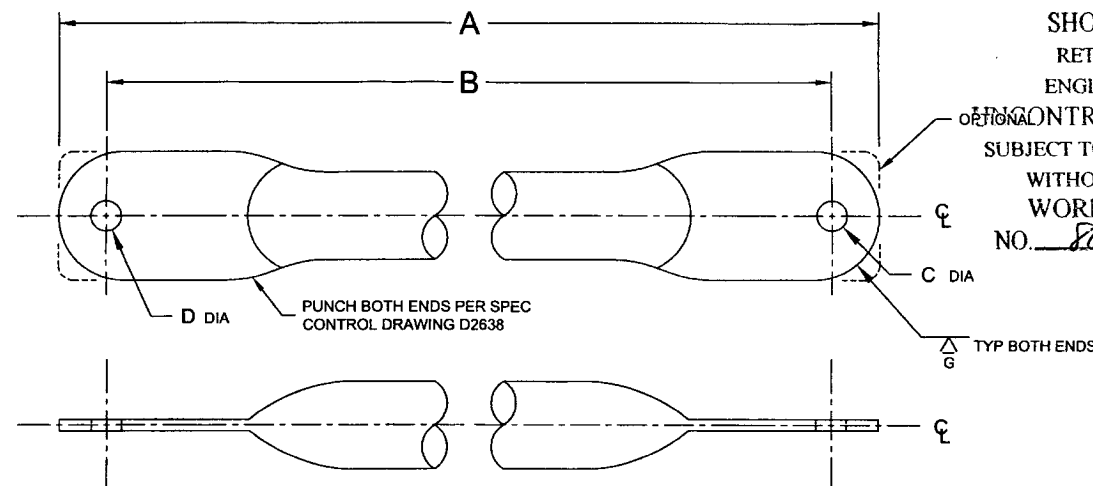
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	A	B	C	D	WEIGHT	FINISH
D3084-1	37.18	36.38	0.257	0.323	0.46 lbs	WHITE POWDER COAT (4.3.5.1) PER DART QSI 4.3
D3084-3	29.80	29.00	0.257	0.257	0.37 lbs	GREY POWDER COAT (4.3.5.6) PER DART QSI 4.3

D3084-XX STRUT
MAKE FROM DT3084-XX
(XX IS THE RESPECTIVE DASH NUMBER)

RELEASED
2010-10-13

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 SEAMLESS TUBING
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8
REF DART SPEC M6061T6T0.750W.058
- 2) FINISH: SEE TABLE FOR POWDER COAT COLOR
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE.
- 7) WEIGHT: SEE TABLE
- 8) WELD PER DART QSI 004.



C	RMV CHEM CONV (NCR 10-059, ZN A6-1)	CP	10.05.18
B	DRAWING REFORMAT. -3 ADDED. NOTES UPDATED	JPH	10.04.13
A	NEW ISSUE	CP	02.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3084	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		STRUT	NTS
DATE	10.05.18	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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